

Date: Tuesday, 20/05/2008 2:21:20 PM
 User: Julie Lecocq

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D350-636-013
 Job Number : 39347
 Estimate Number : 10804
 P.O. Number :
 This Issue : 20/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SKIDTUBES
 Previous Run : 00015
 Written By :
 Checked & Approved By : JUL 08.5.20
 Comment :

Part Number : D350636013
 Drawing Number : R08-041
 Project Number :
 Drawing Revision :
 Material :
 Due Date : 27/05/2008 Qty: 1 Um: Each

Additional Product

Job Number:



DART		TEL.: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-69			
P/N	D350-636-013	CHG	CHG002
DESC	Skidtube Assembly	STC	SH99-7
LOT	B32528	STC	SR00646SE
MODEL	AS350/355	STC	
US PATENT # 5735484 CANADA FOREIGN PATENTS PENDING		MADE IN CANADA	

Seq. #:	Machine Or Operation:	Description :
1.0	D350636013	Skidtube LH
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Skidtube LH ORIGIN B32528 @ CHG002		
2.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Remove all wearplates and hardware. Identify the wearplates, and wearpads, and restock. **** Keep all hardware for the assembly ****		
4.0	D26483	Wearpad
Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s) Wearpad Identify and stock. B31695 Location: <u>FP-20</u>		
5.0	D265613	Wearplate
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Wearplate Identify and stock B30553 Location: <u>FP-16</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 20/05/2008 2:21:20 PM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-636-013

Job Number: 39347

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D265635

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

Identify and stock.

B30554

Location: FP-16

MS

MF

7.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

Identify and stock.

B30141

Location: SCRAP DISCARD

* (X) D3535-25 / B 38867
(X) D3537-1 / B 36363

(X) D3536-25 / B 38565

(X) D3537-1 / B 37292

(X) M521083-C8 / M107939

(X) D3537-1 / B 38254

08-06-04 (X)

add items

Adjust
Accept

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Assemble as per drawing DSI9413 REV.A.

MS

08-06-04 (X)

9.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

B39279

MS

10.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

B39277

MS

11.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

B39276

MS

12.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

B39361

MS

08-06-04

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 20/05/2008 2:21:20 PM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-636-013

Job Number: 39347

Part Number: D350636013

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 D37933 Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Wearshoe B39479 91

14.0 D36721 Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Phenolic Washer B39275 91

15.0 AN526C1032R10 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Screw M108062 92

16.0 AN526C1032R18 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Screw M108079 91

08-06-04

(X1)

17.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 08 06 04 91

18.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT
ORIGINAL KIT WITH TUBE

See below @

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP CHG 004
NEW LABELS REQUIRED

2008.5.20

leo G

8/6/5

(X)

SD

20.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/09

Job Completion



1339347

08-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 4:01:46 PM
User: Kim Johnston

Process Sheet

25

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH
Job Number : 32528
Estimate Number : 10266
P.O. Number : *N/A*
This Issue : 5/23/2007 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : LANDING GEAR
Previous Run : 32527
Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est Rev. 02.09.25 Rearranged procedure steps KJ
est rev 06.03.30 Per rev. D dwg EC

Part Number : D350636013
Drawing Number : D2750 UNDER REVIEW 07.05.24
Project Number : N/A CB
Drawing Revision : D
Material : *N/A*
Due Date : 6/20/2007 Qty: 1 Um: Each

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-013 CHG 002

KS 07.06.04

2.0

D26003BENT

Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1

D2600-3-Bent

Extrusion (Bent)

B30666

7-6-4

3.0

D2744

Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch

329784 BE 07-06-07

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2- Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8864 drilling holes labelled "B" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

7-6-4
7-6-5

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32528

Part Number: D350636013

Job Number:



Seq. #: Machine Or Operation: Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



P10

Comment: INSPECT INSERTS

En 07/08/08 (4)

21.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Wearpad

Batch: B 31695

41

22.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B 30553

41

23.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B 30554

41

24.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B 30141

41

25.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: M 31697

41

26.0

D3488041

BLADE FITTING ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B 29432

41 07-08-03 @

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32528

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description:

27.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B 32598 *

M

28.0

D3492045

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B 32599 *

M

29.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Bolt

Batch: M 104118

M

30.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M 103693

M

31.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M 103668

M

32.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M 103964

M

33.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

Batch: M 102671

M 07-08-03 (1)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32528

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	AN960C10L	washer
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Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: M105057

211

35.0	AN960C816L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M104093

211

36.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M103093

211

37.0	MS21083C8	NUT
------	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M103492

211

38.0	NAS1515H3L	WASHER
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Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

WASHER

Batch: M104603

211

39.0	NAS1515H8L	WASHER
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: M104922

211

40.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Spray inside of tube with "LPS-3" batch: M105085
Inspect for foreign objects as Dart QSI 024

211

04-08-030

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32528

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M1104989

EXP DATE: 08-01

3-Coat all exposed fasteners with "LPS Procyon"

batch: M1104251

W 04-08-03 @

41.0

QC5

INSPECT WORK TO CURRENT STEP



All plugs are



Comment: INSPECT WORK TO CURRENT STEP

installed

En 02/0867 (U)

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

43.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 630556

44.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M104093

45.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M104118

46.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M104117

En 07/18/17 @

Wednesday, 5/23/2007 4:01:47 PM
John Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32528

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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47.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M104955

48.0

D34831

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B32600

49.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CY 07/08/09

B32528